

Date: Monday, 11/05/2009 1:21:17 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG ASSEMBLY
Job Number : 47856	
Estimate Number : 10913	
P.O. Number :	Part Number : D3405043
This Issue : 11/05/2009 S.O. No. :	Drawing Number : D3405 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 47308	Material :
Written By :	Due Date : 28/05/2009 Qty: 12 Um: Each
Checked & Approved By : <u>Julie Dawson 05.11</u>	
Comment : Est A 05.09.01 New issue KJ/JLM Est B 09.01.28 Rev b dwg EC verified by: DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 0.125 Sheet
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Comment: Qty.: 0.1617 sf(s)/Unit Total: 1.9404 sf(s)
 304/316 .125 Sheet
 (M304S11GA)
 Batch: 11018 B95-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3405
 Dwg Rev: B
 Prog Rev: B

B95-15

(12)

2-Deburr if necessary

B95-15

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK8 09/05/15 (+12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Deburr
 Form using DT8204 as per Dwg D3405

SR 09/05/18

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:21:17 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 47856

Part Number: D3405043

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

507/05/08 (X12)

7.0 D34041 GHW Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

GHW Lug

Pick:

Qty Part number Description Batch

1 D3404-1 Lug

A/R SS Rod

47855
M9676

FL 9-5-28 (X12)

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3405

Identify as D3405-043

FL 9-5-28 (X12)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-05-28

(X12)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

507/05/08 (X12)

11.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 1:00pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 1:30pm

FL 09-05-28 (X12)

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/05/28 (12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/05/2009 1:21:17 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY

Job Number: 47856

Part Number: D3405043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST476

SS 09/05/29 (X6)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/01 AJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

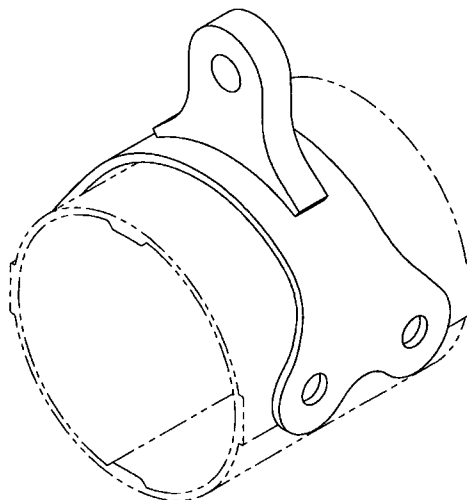
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

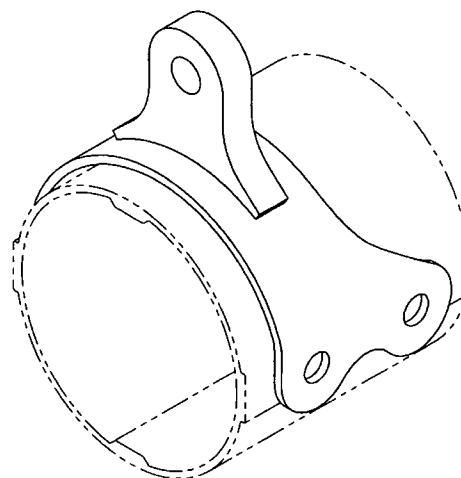
NOTE: Date & initial all entries

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET

△B



D3405-041 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)



D3405-043 LUG ASSEMBLY
(SKID TUBE SECTION SHOWN
FOR REF ONLY)

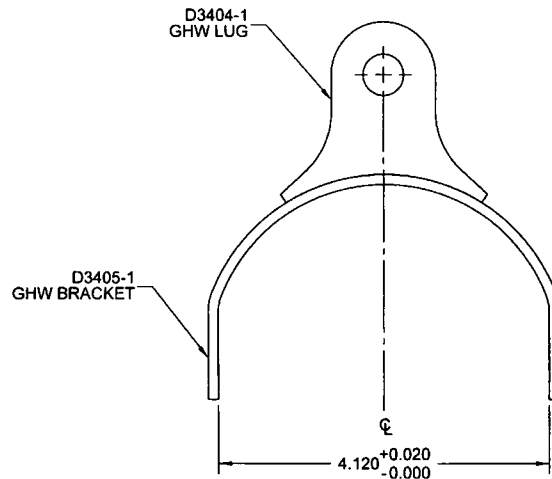
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No. 11800

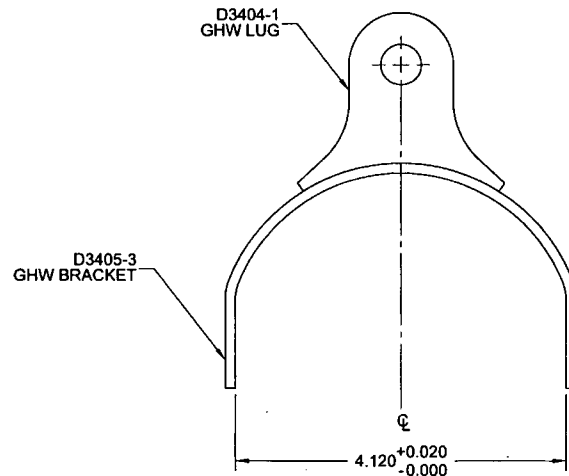
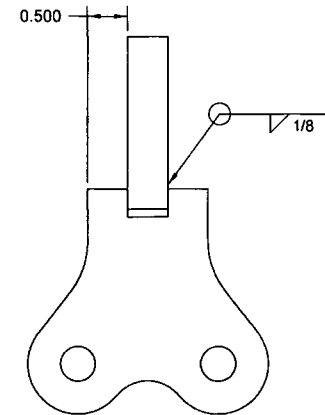
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs
-043, 0.87 lbs

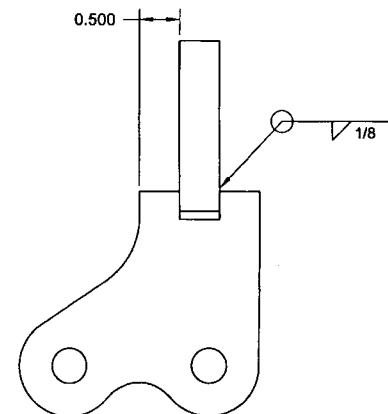
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4 120 DIM WAS 4.100.		AJS	08.09.19
A	NEW ISSUE		PH	05.03.08
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3405	SHEET 1 OF 4	
APPROVED		TITLE	SCALE	
DE APPR.		GHW LUG ASSEMBLY	NTS	
DATE	08.09.19		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



D3405-041 LUG ASSEMBLY



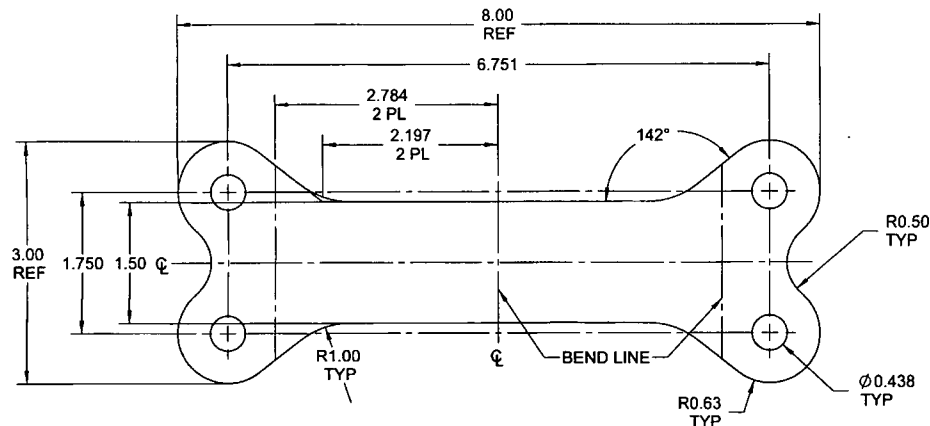
D3405-043 LUG ASSEMBLY



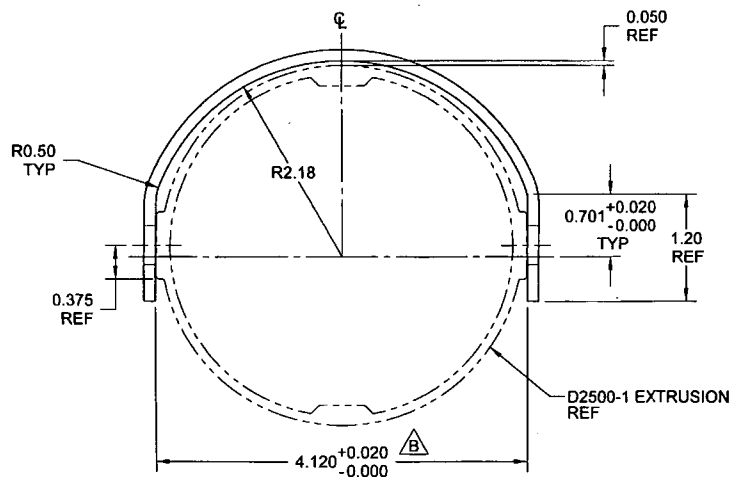
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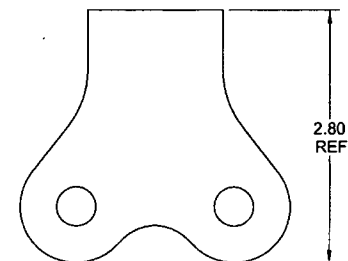
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 2 OF 4
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D3405-1F GHW BRACKET FLAT PATTERN



D3405-1 GHW BRACKET
(MAKE FROM D3405-1F)



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W. R. K. 10/24/10
NO. 118510

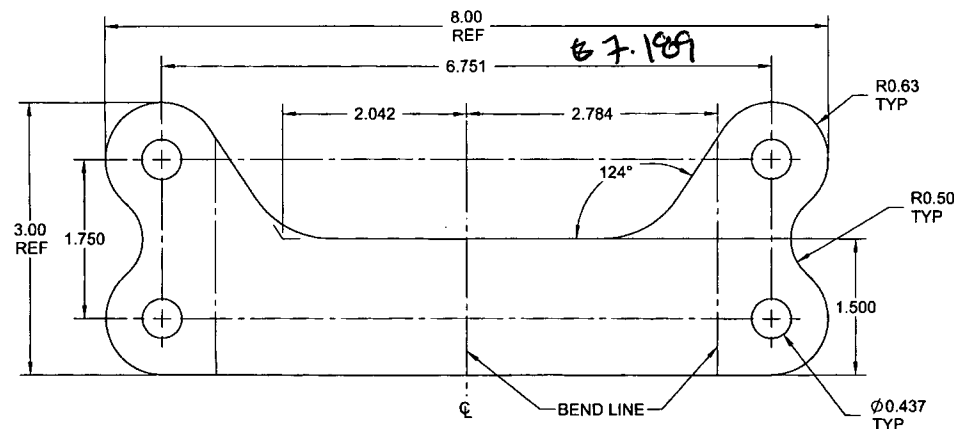
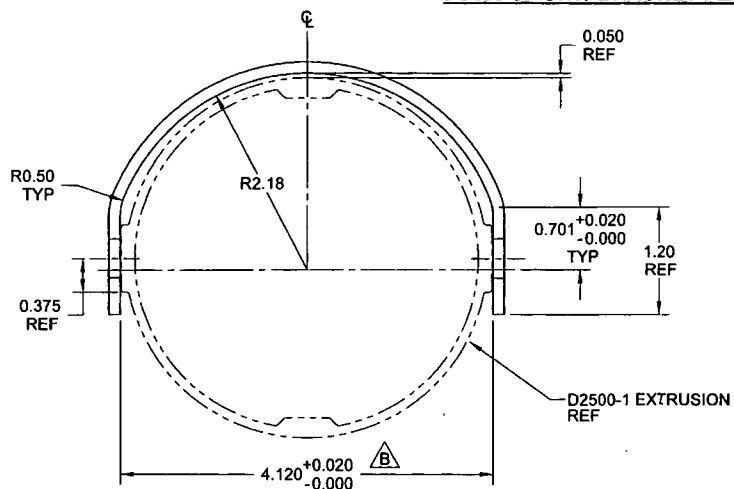
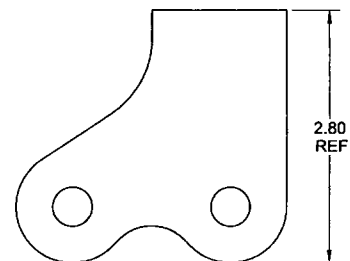
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
10/26/10

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 3 OF 4
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2.188

**D3405-3F GHW BRACKET FLAT PATTERN****D3405-3 GHW BRACKET**
(MAKE FROM D3405-3F)

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WORK ORDER
17856

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

RELEASED
06/12/18

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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
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